Work Orde January-02-13		74			*951	174*	<u>.</u>						Page 1
Item ID: Revision ID: Item Name:	D2199-1 Strut Details	. c			Accept	*N900	040	100)*	Setup	Start Stop	I VI	S1* S2*
Start Date: Required Date: Reference:			ety: 2.00 Qty: 2.00	*2* *2*		Cust Item l Customer:	ID:						
Approvals:	Process Plan	:	U	Date: 13-01-7	Tooling:	D	ate:			Run	Start	*N	R1*
	~~		/- ` 	Date:	SPC (Y/N):	D	ate:	·			Stop	*N	R2*
Sequence ID/ Work Center II		Operati Descrip			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Revis	ion Nb	•										881-1
D2199	Rev E	E 1	ì										0,000
100					0.00								
100	•	NC BRAI	ζE						2				
Brake NC Brake NC			Mem o Punch per D	wg. D2199 and Spec Contro	0.00 ol Dwg D2638								
				d			•						
110		C 11 C.L			0.00				2			,	
110 Small Fab		Small Fab	Memo Deburr		0.00			·		<u> </u>			<u> </u>
120 *120*		QC5- Insp	pect part comple	eteness to step on W/O	0.00	27			ى ئ				
QC Quality Control		*,	Memo		0.00	-S-15				·			· · · · · · · · · · · · · · · · · · ·

WORK ORDER NON-CONFORMANCE / UPDATE

NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** DISPOSITION Work Order: Skid-tube Water Jet Engineering Crosstube Rework Quality Machining Small Fab Prod. Eng. Coor. Part No. Scrap Other Thermoforming Rec/Store/Packaging Use-as-is Finishing NCR No. Supplier Work Order Update Large Fab Composite Description of work order update Action Sign & Initial Root or Non-conformance QC Inspector Chief Eng Description Verification Date Step Qty Date Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Pressure/Forced Bend Grain Ovalized Bending BOM/Route Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Hardware Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld Wrong Stock Pulled Crushed/Crimped, Burrs Instructions Incomplete/Unclear Part Lost/Missing Cuffs Maintenance Part Moved Contamination Countersink Mislabeled Positioned Wrong Heat Treat Other Cut Too Short Misread Power Loss/Surge Inspection Strip in Tube Drill Holes Offset Ripples in Bend **Torque Waves in Extrusion** Drawing Out of Calibration **Turning Sequence** Finish Out of Sequence

Outside Dimensions

Wave/Twist in Tube

Folio

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Work Orde		174	A man to the second sec	*951	74*				Page 2
Item ID: Revision ID: Item Name:	D2199-1 Strut Details		<u> </u>	Accept	*N900040	1100*	Setup	Start Stop	*NS1* *NS2*
Start Date: Required Date: Reference:	1/02/13 1/25/13	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item ID: Customer:				
Approvals:	Process Pla	in:	Date:	Tooling: SPC (Y/N):	Date: Date:		Run	Start Stop	"NRT"
Sequence ID/ Work Center II 130 *130* Powdercoat Powder Coating 140 *140* QC Quality Control	,20	Memo START TIM QC3- Inspect Part Finish	IE:FINISH TIME:	Set Up/ Run Hours 0.00 0.00 OVEN TEMPERATURE 0.00 0.00 0.00	Tool ID Tool #	Plan According Code Qty	Qt.	•	Reject Insp. Number Stamp 13 Jos As 13 (3 6 5 5 5 7 1 1 1 1 1 1 1 1 1

0.00

Identify as per dwg & Stock Location: 870 40.00

Memo

150

150
Packaging

Packaging

		DQA:	Date:	
JCR· Ves / No	WORK ORDER NON-CONFORMANCE / LIPDATE			

NCR:	Yes	/ No				WORK ORDER NON-	CON	IFOR	MANCE / UP	DATE			
										- 	QA Closed:	Date	:
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	_ No					Rework Scrap Use-as-is		Skid-tube Cross Machining Sm. Thermoforming Fir				Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR I	No					Work Order Update]		Large Fab	Composite		Supplier	
Root Desc						ption of work order update	lr	nitial	Act	tion	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Chi	ef Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data					•								
Equip/Tooling													
Operator													
Material													
Setup													
Other													
Process													
Supplier													
Training										,			
Unapproved													
						F.	AUL	CATE	GORY				
Landi	ng Ge	ar				General							
	В	ending			L	Bend		Grain			Ovalized		Pressure/Forced
	Шс	entre No	t Concen	ntric to ()/S	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks					Broken/Damaged		Inspecti	on Incomplete		Part Incorred	ct _	Weld
	Crushed/Crimped_					Burrs		Instruct	ions Incomplete/l	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	C	uffs				Contamination		Mainte	nance		Part Moved		
	Heat Treat					Countersink		Mislabe	led		Positioned V	Vrong	_
	Ir	spection	Strip in	Tube		Cut Too Short		Misread	I		Power Loss/Surge Other		
	R	ipples in	Bend			Drill Holes		Offset					
	T	orque W	aves in E	xtrusior	ı	Drawing		Out of 0	Calibration				

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

Folio

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Work Ord January-02-13		3174						Page 3				
Item ID: Revision ID: Item Name:	D2199-1 Strut Details			Accept	*N900	040	100)*	Setup	Start Stop	1.71	S1* S2*
Start Date: Required Date:	1/02/13 1/25/13	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item I Customer:	D:						
Reference:										~		
Approvals:	Process Pla	an:	Date:	Tooling:	Da	ite:			Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):	Date:					Stop	*N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
160		QC21- Final Inspection -	Work Order Release	0.00							11.	1-10
160 QC Quality Control		Memo	·	0.00					у.	13 M	15/19	3-05-18

DQA:	Date:	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

	•									QA Closed:	Dat	e:
Work Orde	.			DISPOSITION AGAINST DEPARTMENT/PROCESS								
Part N NCR N	0				Rework Scrap Use-as-is Work Order Update		Engineering Quality Other					
Root				Descri	ption of work order update	In	itial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chie	ef Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data				····								
quip/Tooling												
Operator					÷	1			·			
Material		1				1						
Setup												
Other												
Process					•						r	
Supplier					•							
raining [•				
Jnapproved												
					F	AULT	CATE	GORY				
Landin	g Gear				General					_	_	· ·
	Bending				Bend		Grain		L_	Ovalized		Pressure/Forced
L	Centre No	ot Concer	ntric to (o/s	BOM/Route	<u> </u>	Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		nspecti	on Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped,			Burrs	<u> </u>	nstruct	ions Incomplete/	Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		
	Heat Trea	it			Countersink		Mislabe	led		Positioned V	Vrong	
Γ	Inspection	n Strip in	Tube		Cut Too Short		Misreac	i		Power Loss/	Surge	Other
Ī	Ripples in	Bend			Drill Holes		Offset		_			
ſ	Torque W	aves in E	xtrusio	1	Drawing		Out of C	Calibration				
ľ	Turning S			Finish	\Box	Out of S	Sequence					
	Wave/Tw	ist in Tub	e		Folio	П	Outside	Dimensions				

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Picklist Print

January-02-13 2:31:28 PM

Work Order ID:

95174

Parent Item:

D2199-1

Parent Item Name:

Strut Details

Start Date: 1/02/13

Required Date: 1/25/13

Page 1

Start Qty: 2.00

Required Qty: 2.00

Comments:

B02.06.10Added finish NG/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No		· · · · · · · · · · · · · · · · · · ·	100	f	457.0240	1.55	3.2631578		0-	/
304 RD Tube .750 x .049W	<i>!</i> .								Constitution of the Consti			<i>S</i> 3	, 131a
				Location		Loc Qty	<u>Lo</u>	c Code					
				MAT017		457.0240325							
				1093	314	18.666							
				1110	519	6							
				112	187	8							
	*			120	141	0.008734							
				121	170	234.89			*****				
				121	566	15.134							
7e				122	312	64.43							
				1224	168	109.895299				¥6,			

												DQA:	Date:				
NCR:	Yes	/ No					WORK ORDER NON-C		NFOR	MANCE / UPDA							
												QA Closed:	Date:				
Work Ord	er:						DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Part I							Rework Scrap Use-as-is				Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other			
NCR I	No.						Work Order Update			· —	Composite	,	Supplier				
Root					Des	cri	otion of work order update		nitial	Action	1	Sign &					
Cause		Date	Step	Qty		c	or Non-conformance	Ch	ief Eng	Descript	ion	Date	Verification	QC Inspector			
oc/Data quip/Tooling perator													•				
laterial etup ether													•				
rocess upplier				-						:		,					
raining napproved																	
паррточец	Щ			1			F	AUL	T CATE	GORY		l					
Landi	ng (Gear		***			General						<u> </u>				
	_	Bending					Bend		Grain			Ovalized		Pressure/Forced			
		Centre No	t Concer	ntric to (D/S		BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure			
		Cracks Broken/Damaged								on Incomplete		Part Incorred	ct	Weld			
		Crushed/Crimped. Burrs							Instruct	ions Incomplete/Unc	lear	Part Lost/Mi	ssing	Wrong Stock Pulled			
		Cuffs					Contamination		Mainte	enance		Part Moved					
		Heat Trea	t				Countersink		Mislabe	eled		Positioned V	Vrong				
	Inspection Strip in Tube Cut Too Short								Misread	1		Power Loss/	Surge	Other			
	Ripples in Bend Drill Holes								Offset					· · · · · · · · · · · · · · · · · · ·			
		Torque W	aves in E	xtrusio	า		Drawing		Out of	Calibration							
	Turning Sequence Finish Out of Sequence								Sequence								

Outside Dimensions

Wave/Twist in Tube

Folio

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